

## ABSTRACT OF THE DISCLOSURE

A molded glass substrate for a magnetic disk is manufactured in the following manner: press-molding a heated glass material in the inside space  
5 of a molding die including a pair of dies, each having a predetermined processing plane, and a barrel die for slidably guiding the dies while forming the outer circumference of the glass material joined to both principal surfaces corresponding to the dies as a molding-free face; cooling the press-molded glass substrate; and forming a predetermined  
10 through-hole in the central portion of the glass substrate. This method enables manufacturing that prevents generation of industrial waste, such as glass power, abrasive, and solvent, as much as possible.